

Work Order ID 101492 - 2

101492

Page 1

May-13-13 1:03:05 PM

Item ID: D4406-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Aft Wearplate Assembly

Start Date: 5/13/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan: ML3

Date: 13-05-16

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4406

C

100

0.00

100

Waterjet

FLOW CNC Waterjet

304 1050

Memo

1-Cut as per dwg D4406-3

prog rev: C

dwg rev: C

2-Deburr if required

0.00

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

4

0

Jm13-5-22

4

0

Jm13-5-22

Work Order ID 101492

101492

Page 2

May-13-13 1:03:05 PM

Item ID: D4406-043 Accept *N9000040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Aft Wearplate Assembly
Start Date: 5/13/13 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 5/24/13 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				4			
130 *130* Small Fab Small Fab	Form as per dwg D4406	0.00 0.00				4			SB 6/05/24
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				4			

Work Order ID 101492

101492

Page 3

May-13-13 1:03:05 PM

Item ID: D4406-043

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Wearplate Assembly

Start Date: 5/13/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

0.00

150

Large Fab

Memo

0.00

Large Fab

Weld bar as per dwg

A/R 2059b hardcoat Batch#: M125126

Weld bar to wearplate as per dwg

A/R s.s. rod Batch#: M126048

x2

13-06-26 MAL

160

0.00

160

QC

Memo

0.00

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

(2) 13-06-27 PD

165

0.00

165

QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

(2) 13-06-27 PD

Work Order ID 101492

101492

Page 4

May-13-13 1:03:05 PM

Item ID: D4406-043

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Wearplate Assembly

Start Date: 5/13/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: Date: Tooling: Date:

Stop *NR2*

QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		0.00				2	0	0	AB
170		0.00							13-7-6
Small Fab	Memo								
Small Fab	Apply coating as per dwg D4406								
	125382								
180	QC5- Inspect part completeness to step on W/O	0.00				2			
180		0.00							
QC	Memo								
Quality Control									
190	Identify as per dwg & Stock Location: H-002	0.00							
190		0.00							
Packaging	Memo								
Packaging									

2 0 BL 1378

Work Order ID 101492

101492

Page 5

May-13-13 1:03:05 PM

Item ID: D4406-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Aft Wearplate Assembly

Start Date: 5/13/13 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 4.00

4

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

13/7/8
MF
13-7-8

Picklist Print

May-13-13 1:03:04 PM

Page 1

Work Order ID: 101492
 Parent Item: D4406-043
 Parent Item Name: Aft Wearplate Assembly

Start Date: 5/13/13
 Start Qty: 4.00

Required Date: 5/24/13
 Required Qty: 4.00

Comments: IPP Rev A 11.06.06new issue EC verified by:DD
 revPB1 DD verf:EC
 IPP rev B 12.02.06 as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4407-3 Bar		Manufactured	No			150	Each	16.0000	2	8			

Location Loc Qty Loc Code
 WA001 16

x4 13-06-26 MAL

M304S18GA
 304/316 .050 Sheet

Purchased No

99127 543 X4

100 sf 397.1699 2.92 12.294737
 13

JMB-5-22

Location Loc Qty Loc Code
 MAT019 302.8
 117188 5
 117766 5
 120604 5
 122325 3
 123155 3
 124572 153.8
 125552 128
 MAT020 94.369894
 120243 2
 121626 1.529894
 124029 90.84

125552

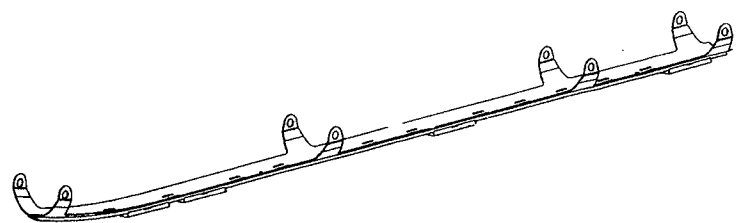
DART AEROSPACE LTD		Work Order:	101492
Description: Plate		Part Number:	D4406-3
Inspection Dwg: D4406 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

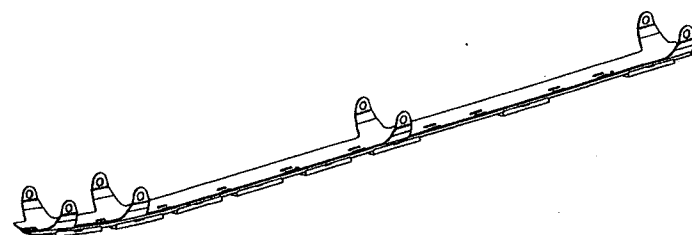
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.561	+/-0.010	0.565"	-		✓	Jkm01
0.30	+/-0.030	0.307"	-		✓	
0.88	+/-0.030	0.882"	-		✓	
0.13	+/-0.030	0.135"	-		✓	
0.31	+/-0.030	0.310"	-		✓	
24.995	+/-0.010	24.995"	-		T	Jkm06
47.958	+/-0.010	47.958"	-		T	
54.178	+/-0.010	54.178"	-		T	
2.43	+/-0.030	2.428"	-		✓	
7.77	+/-0.030	7.772"	-		✓	
7.203	+/-0.010	7.207"	-		✓	
3.63	+/-0.030	3.640"	-		✓	
4.00	+/-0.030	4.012"	-		✓	
7.071	+/-0.010	7.076"	-		✓	
7.800	+/-0.010	7.802"	-		✓	
0.050	+/-0.010	0.047"	-		✓	

Measured by: Jm	Audited by: DAP 27	Preliminary Approval:
Date: 13-5-22	Date: 15-5-23	Date:

Rev	Date	Change	Revised by	Approved
A	11.10.13	New Issue P/O D4406-043	KJ	
B	12.03.08	Dimensions revised per Dwg Rev B	KJ	
C	13.05.08	Dwg Rev updated	KJ	M



D4406-041 FWD WEARPLATE ASSY



D4406-043 AFT WEARPLATE ASSY

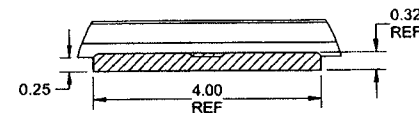
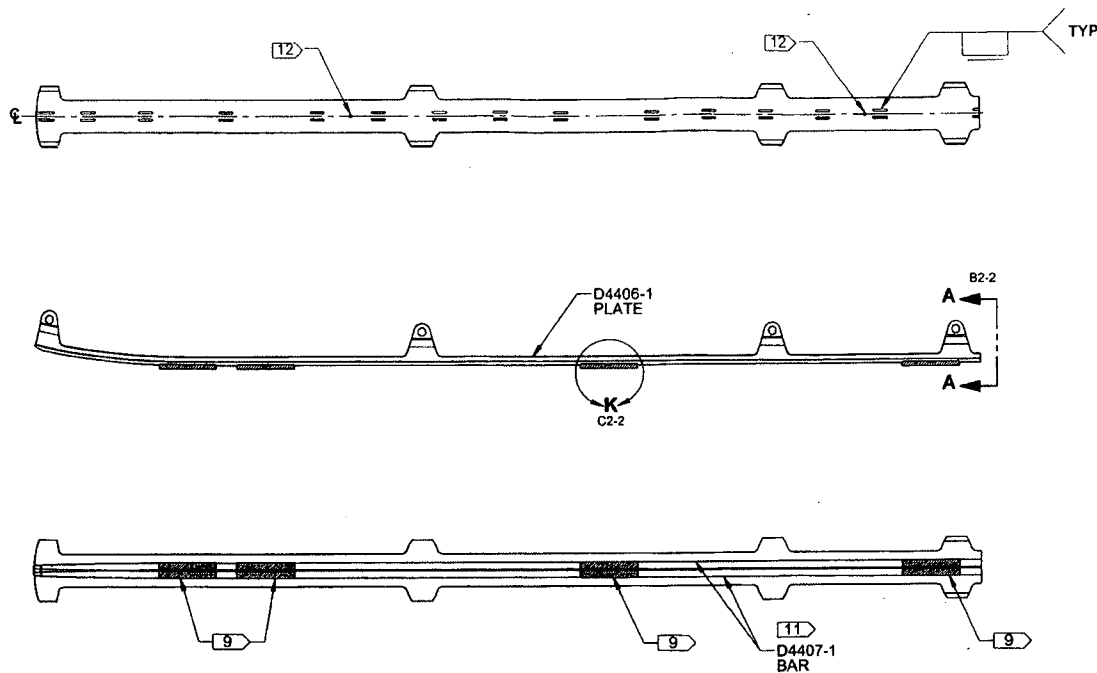
ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D4406-041	FWD WEARPLATE ASSY
2		X	D4406-043	AFT WEARPLATE ASSY
3	1		D4406-1	PLATE
4		1	D4406-3	PLATE
5	2		D4407-1	BAR
6		2	D4407-3	BAR
7	A/R	A/R	2059B	HARDCOAT
8	A/R	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 10, SHT 2 & 3)

101492 MJS
13-05-16

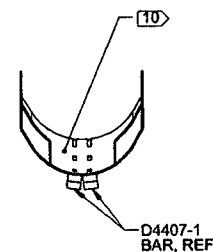
RELEASED
2013-03-21

C	SHEETS 4 AND 5 HOLE SLOTS RE-PITCHED. SHT 5 FWD SLOT SIZES WERE 0.88 (REF NCR12-2031).	AJS	13.03.11
B	REVISE BILL OF MATERIAL: ADD NOTE 13/14 & REVISE NOTE 9 SHT 2 & 3; MODIFY DETAIL E & F (ZN B3-6, C2-8); ADD DETAIL G (ZN C7-6); REVISE D4406-3F TAB LOCATIONS (ZN B5-5)	RF	12.02.16
A	NEW ISSUE	RF	11.08.15
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	UP	DRAWING NO.	REV. C
MFG. APPR.	JA	D4406	SHEET 1 OF 6
APPROVED	INT	TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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101496



DETAIL K CS-2
WELD BUILDUP DETAIL 4 PL
SCALE 4X



SECTION A-A C3-2
SCALE 2X

D4406-041 FWD WEARPLATE ASSY

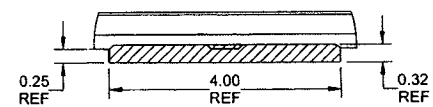
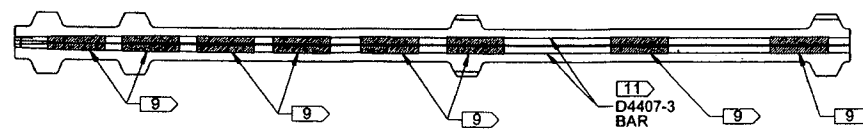
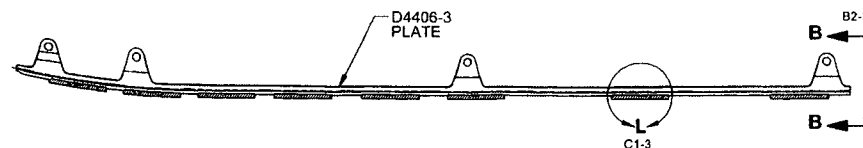
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.48 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D4407-1 BAR ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-1 AT TIME OF WELDING
- 12) TRANSFER Ø0.188 HOLES FROM D4406-1 TO D4407-1
- 13) NOTCH D4407-1 BARS AS REQUIRED TO FORM TO D4406-1 PLATE

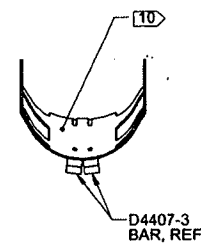
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2013-03-21

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	97	DRAWING NO.	REV. C
MFG. APPR.	KS	D4406	SHEET 2 OF 6
APPROVED	147	TITLE	SCALE
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DETAIL L C4-3
WELD BUILDUP DETAIL 8 PL
SCALE 4X



SECTION B-B C3-3
SCALE 2X

D4406-043 AFT WEARPLATE ASSY

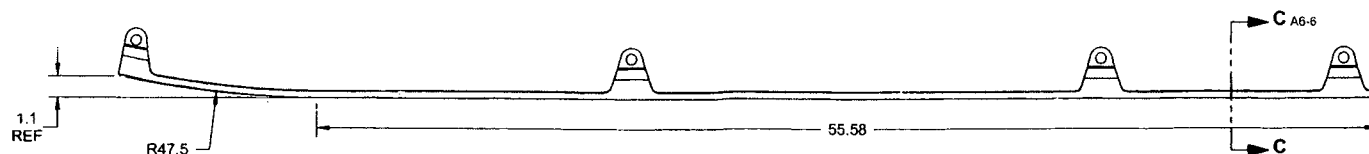
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.85 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D4407-3 BAR ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-3 AT TIME OF WELDING
- 12) FILL TOOLING HOLE WITH WELD ONE PLACE ONLY
- 13) TRANSFER $\phi 0.188$ HOLES FROM D4406-3 TO D4407-3
- 14) NOTCH D4407-3 BARS AS REQUIRED TO FORM TO D4406-3 PLATE

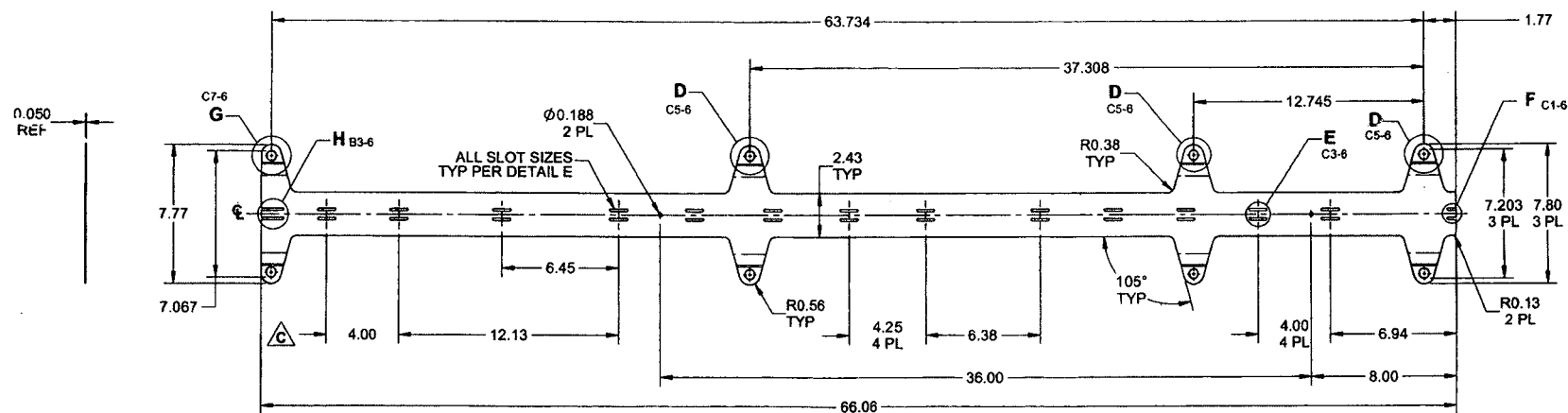
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DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. C
MFG. APPR.	JS	D4406	SHEET 3 OF 6
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D4406-1 PLATE
(MAKE FROM D4406-1F)



D4406-1F FLAT PATTERN

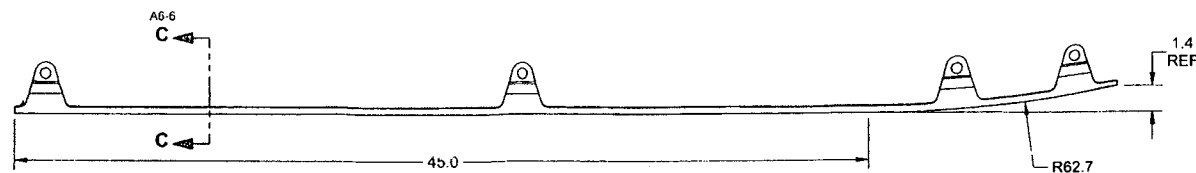
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2013-03-21
WNS

NOTES:

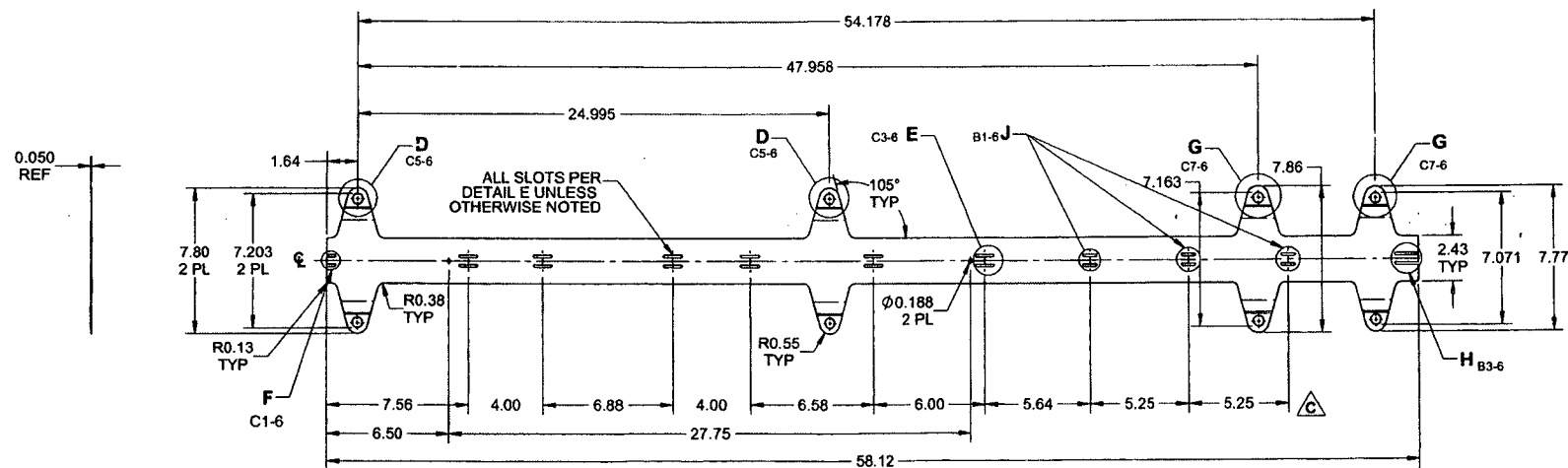
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.7 lbs

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4406	SHEET 4 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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D4406-3 PLATE
(MAKE FROM D4406-3F)



D4406-3F FLAT PATTERN

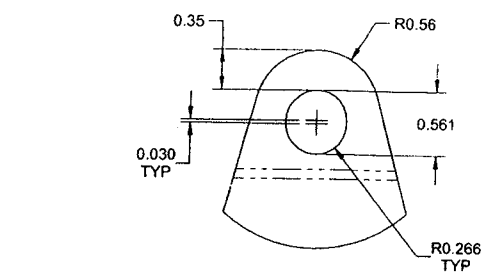
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2013-03-21
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NOTES:

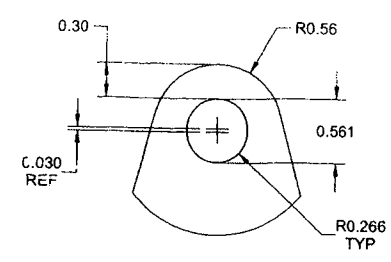
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.5 lbs

DESIGN	RF	DART AEROSPACE LTD	
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4406	SHEET 5 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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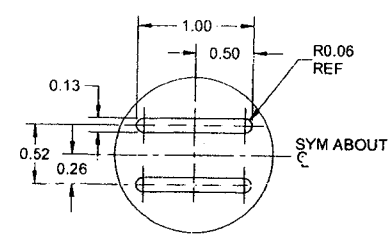
101492



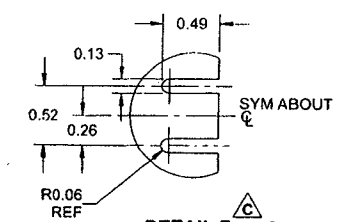
DETAIL G
SLOT DETAIL TYP
SCALE 6X



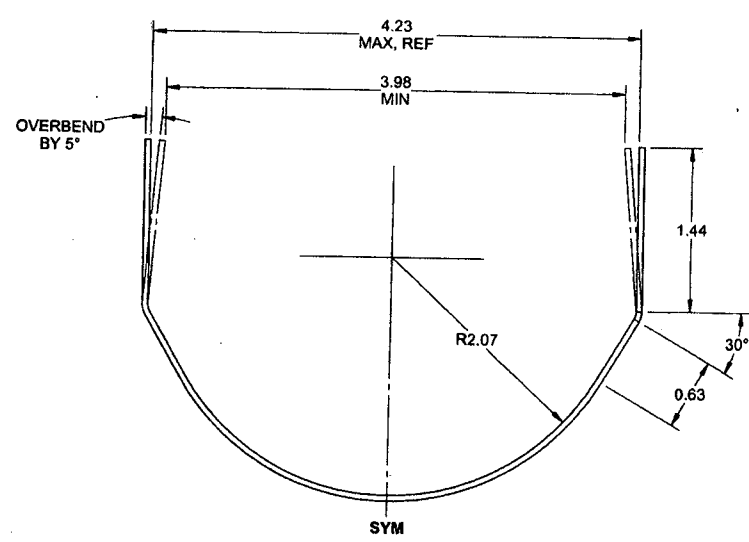
DETAIL D
SLOT DETAIL TYP
SCALE 6X



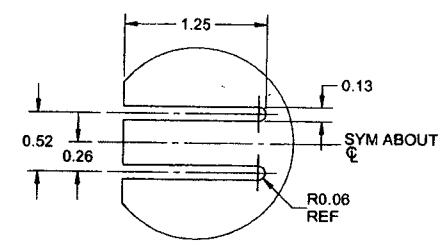
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SCALE 6X



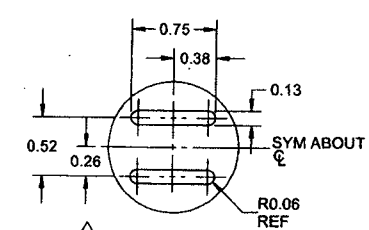
DETAIL F
SLOT DETAIL TYP
SCALE 6X



DETAIL C
DETAIL TYP
SCALE 6X



DETAIL H
SLOT DETAIL TYP
SCALE 6X



DETAIL J
SLOT DETAIL TYP
SCALE 6X

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2013-03-20

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. C
MFG. APPR.	JS	D4408	SHEET 6 OF 6
APPROVED	JS	TITLE	SCALE
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